

633-017

Dart Aerospace Ltd.

Date: Thursday, 2/14/2008 10:54:42 AM
 User: Kim Johnston

13

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	STEP WELDMENT
Job Number	37415A			
Estimate Number	10176			
P.O. Number	:		Part Number	: D2563
This Issue	: 2/14/2008	S.O. No. :	Drawing Number	: D2563 REV C
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: / /	Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	36512		Material	:
Written By	:		Due Date	: 3/25/2008
Checked & Approved By	:	108 02 14	Qty:	2
Comment	Est Rev 0	02.07.31 Re-format Location RF	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2244116	Step Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) ✓	
		Pick:	
		1 D2244 Step Extrusion	
		Batch: B33733	SAP 08/04/19 Z
2.0	D267334	End Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part No. Description	Batch
		2 D2673-34 End Cap	B36406
			 08.04.28 Z
3.0	D2561	Lug Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part No. Description	Batch
		2 D2561 Lug Plate	B36533
			 08.04.28 Z
4.0	D2564	Mounting Angle	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part No. Description	Batch
		2 D2564 Mounting Angle	B375336533
			 08.04.28 Z

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 10:54:42 AM
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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: STEP WELDMENT
Job Number: 37415A		Part Number: D2563
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563		
2-Deburr ends SAP 08/04/19 (2)		
3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343 A/R AL ROD Batch: <u>M106834</u> <u>M106762</u> 08.04.28 (2)		
4- Grind SAP 08/04/29 (2)		
6.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION 08-04-30 (2)		
7.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP 08/04/30 (2)		
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 M.F. 08/04/30 (2)		
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 08-04-30 (2)		
10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 08-05-05 (2)		
1-Inspect for foreign object per QSI 024		
2-Weld Remaining End as per Dwg D2563 using DT 8343 A/R AL ROD Batch: <u>M106834</u> 08-05-05 (2)		
3-Grind SAP 08/05/06 (2)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 37415A		Part Number: D2563
Job Number:		
Seq. #:	Machine Or Operation:	Description :
11.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		08/05/06 (2)
12.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		08/05/06 (2) 1337415A 102563 07/05/2008
13.0	POWDER COATING	POWDER COATING M107550
Comment: POWDER COATING Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		- Fx 08/05/06 (2) #1 321.9 F #2 --- F #3 3cmeters F
14.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 m107380 M107550
Comment: HAND FINISHING RESOURCE #1 Wing Walk as per Dwg D2563 and QSI 005 4.4		Fx/21 08/05/07 (2) #4 --- F
15.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION M107550
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		08/05/07 (2)
16.0	QC21	FINAL INSPECTION/W/O RELEASE M107550
Comment: FINAL INSPECTION/W/O RELEASE		08/05/07 (2)
Job Completion		 MF 08-05-08

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

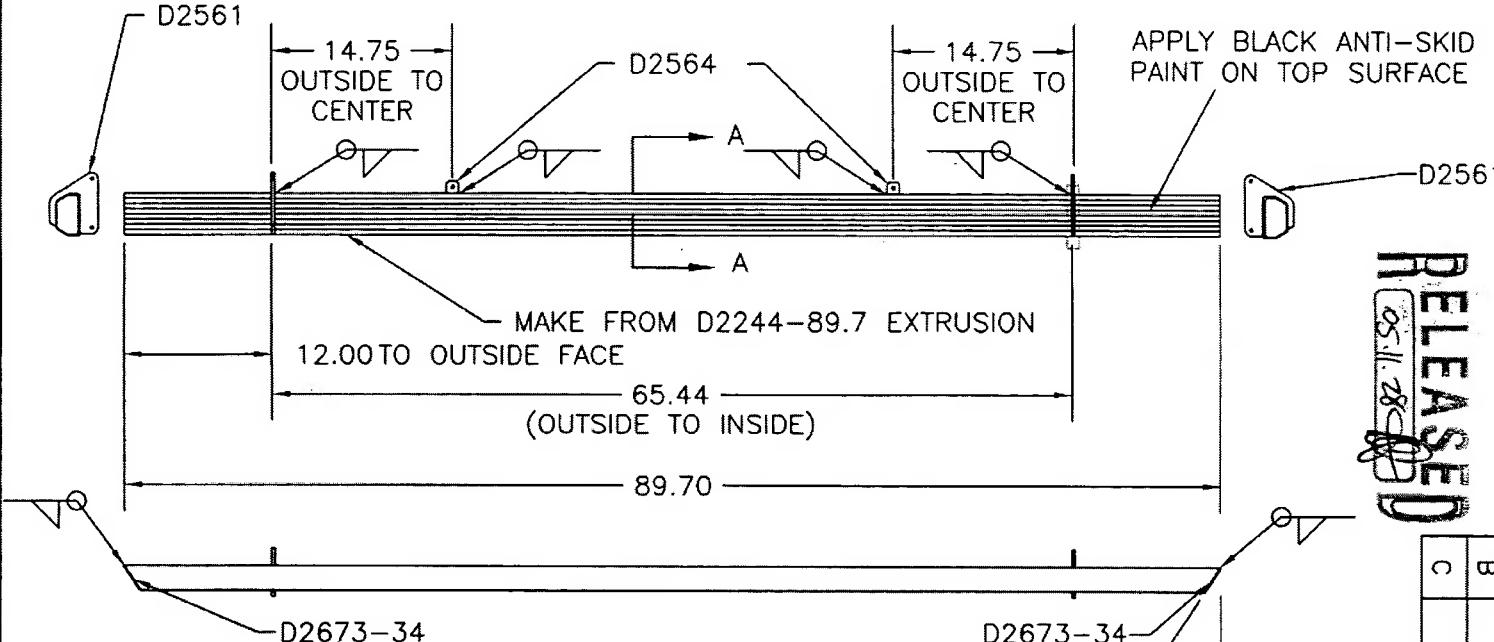
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED
05/11/2000



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 3415A

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN BW	DRAWN BY <i>Pf</i>	DART AEROSPACE LTD	
CHECKED <i>H</i>	APPROVED <i>H</i>	HAWKESBURY, ONTARIO, CANADA	
DATE 05.11.14	DRAWING NO. D2563		REV. C
	TITLE STEP WELDMENT ASSEMBLY		SHEET 1 OF 1
A	96.04.26	NEW ISSUE	SCALE 1:15
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	